

Work Order ID 77711-2

December-19-11 8:21:30 AM

77711

Page 1

Item ID: D139-799-013

Revision ID:

Item Name: Cargo Door Hinge

Start Date: 19/12/2011 Start Qty: 6.00

Required Date: 02/01/2012 Req'd Qty: 6.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: M.L.J

Date: 11/12/11

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9567

A

IIN-D139-799

E

100

100

DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D139-799-013

CHG 883

per 12-507

0.00

0.00

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

ml 12 01 31 (5)
for M.L.J 12-1-5
(6)

12/1/3 SP

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-19-11 8:21:34 AM

Page 1

Work Order ID: 77711

77711

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 19/12/2011

Required Date: 02/01/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:JLM
AS PER ECN 11-598 11-06-05 JLM VERIFIED BY:DD
IPP REV:C AS PER DSI9567 revA 11.10.17 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2585
D2585
Mounting Channel

Manufactured No

110 Each 29.0000

1 6

**

Location

Loc Qty

Loc Code

ST017

29

73297

2

74488

27

Manufactured No

110 Each 31.0000

1 6

**

Location

Loc Qty

Loc Code

ST204

31

74489

31

Manufactured No

110 Each 14.0000

1 6

**

Location

Loc Qty

Loc Code

ST019

14

73304

14

Manufactured No

110 Each 7.0000

1 6

**

Location

Loc Qty

Loc Code

ST272A

7

74847

6

76340

1

D2621
D2621
Latch Plate, 350 Spacepod

Manufactured No

110 Each 14.0000

1 6

**

D3552-23
D3552-23
Door Prop

Manufactured No

110 Each 7.0000

1 6

**

12/1/11
B78 366 SP
12-01-12.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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December-19-11 8:21:34 AM

Work Order ID: 77711

77711

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 19/12/2011

Required Date: 02/01/2012

Start Qty: 6.00

Required Qty: 6.00

D3622-1
D3622-1
Ball Stud

Manufactured No 110 Each 38.0000

1 6
**

Location Loc Qty Loc Code

ST070 38
76889 38

Manufactured No 110 Each 25.0000

1 6
**

Location Loc Qty Loc Code

ST070 25
53951 4
72103 1
77023 20

Manufactured No 110 Each 0.0000

2 12
**

D4072-1
D4072-1
Airframe Hinge

Manufactured No 110 Each 5.0000

2 12
**

D4072-3
D4072-3
Airframe Hinge Backing Plate

Location Loc Qty Loc Code

ST120 5
74270 5

Manufactured No 110 Each 23.0000

4 24
**

D4072-5
D4072-5
Bushing

Location Loc Qty Loc Code

ST120 23
76943 23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 3

December-19-11 8:21:34 AM

Work Order ID: 77711

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Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 19/12/2011

Required Date: 02/01/2012

Start Qty: 6.00

Required Qty: 6.00

D4073-1
D4073-1

Door Hinge

D4073-3
D4073-3

Door Hinge Backing Plate

Manufactured No

110 Each

0.0000

2 12

**

Manufactured No

110 Each

15.0000

2 12

**

Location

Loc Qty

Loc Code

ST120

15

74269

15

Manufactured No

110 Each

28.0000

1 6

**

D4074-1
D4074-1

Bracket

Location

Loc Qty

Loc Code

ST120

28

74494

4

76338

24

Manufactured No

110 Each

16.0000

1 6

**

D4074-3
D4074-3

Channel

Location

Loc Qty

Loc Code

ST120

16

72110

16

Manufactured No

110 Each

108.0000

1 6

**

D4074-5
D4074-5

Backing Plate

Location

Loc Qty

Loc Code

ST120

108

74495

96

76339

12

December-19-11 8:21:34 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 77711

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Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 19/12/2011

Required Date: 02/01/2012

Start Qty: 6.00

Required Qty: 6.00

D4074-7

Manufactured

No

110

Each

6.0000

1

6

D4074-7

Striker Plate

**

326887

Location

Loc Qty

Loc Code

ST120

6

75624

6

Purchased

No

110

Each

7,008.000

20

120

MS21042L3

MS21042L3

Nut

**

120

Location

Loc Qty

Loc Code

ST300

7008

117441

16

117885

32

118451

5

118927

3

119017

5994

119075

958

Purchased

No

110

Each

2,142.000

1

6

MS21042L5

MS21042L5

Nut

**

12/1/13

Location

Loc Qty

Loc Code

ST300

2142

116105

5

116548

43

117611

52

118179

496

118910

46

119109

1500

42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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December-19-11 8:21:34 AM

Page 5

Work Order ID: 77711

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

77711

D139-799-013

Start Date: 19/12/2011

Required Date: 02/01/2012

Start Qty: 6.00

Required Qty: 6.00

MS27039-1-10

Purchased

No

110

Each

45.0000

8

48

MS27039-1-10

Screw

**

Location

Loc Qty

Loc Code

ST291

45

119307

3

119531

42

MS27039-1-14

Purchased

No

110

Each

26.0000

2

12

MS27039-1-14

Screw

**

Location

Loc Qty

Loc Code

ST291

26

112312

26

MS27039-1-16

Purchased

No

110

Each

144.0000

8

48

MS27039-1-16

Screw

**

Location

Loc Qty

Loc Code

ST291

144

118612

1

119902

143

MS27039-1-17

Purchased

No

110

Each

49.0000

1

6

MS27039-1-17

Screw

**

Location

Loc Qty

Loc Code

ST291

49

117591

49

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-19-11 8:21:34 AM

Work Order ID: 77711

77711

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 19/12/2011

Required Date: 02/01/2012

Start Qty: 6.00

Required Qty: 6.00

NAS1149D0363J

Purchased

No

110

Each

2,459.000

18

108

NAS1149D0363.I

Washer

**

Location

Loc Qty

Loc Code

ST298

2459

117601

61

118077

1

118612

18

118968

207

119537

2172

NAS1149D0663J

Purchased

No

110

Each

1,880.000

1

6

NAS1149D0663.I

Washer

**

Location

Loc Qty

Loc Code

ST298

1880

119075

1880

NAS1515H5L

Purchased

No

110

Each

194.0000

4

24

*NAS1515H5I *

WASHER

**

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

154

118614

1

119902

153

PTO

W/O: 77711		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
12-01-19		Add to kit per ECN 12-507 1x D4519-1 B 79090 1x IN4007 B M114970 mhl	SD	12/1/23			mhl 12-01-31	
		1x M12883/4149 B 120251 4x M39029/92-534 B 120344 1x M83536/9-024M B 120251 x5 All ready done 12-02-01	SD	12/1/23			mhl 12-01-31	

Part No: D139-799-013 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -013	Part Number	Description
X	D139-799-013	CARGO DOOR HINGE KIT
1	D2585	MOUNTING CHANNEL
1	D2586	DOOR LATCH
1	D2621	LATCH PLATE
1	D3552-23	DOOR PROP
1	D3622-1	BALL STUD
1	D3622-3	BALL STUD
2	D4072-1	AIRFRAME HINGE
2	D4072-3	AIRFRAME HINGE BACKING PLATE
4	D4072-5	BUSHING
2	D4073-1	DOOR HINGE
2	D4073-3	DOOR HINGE BACKING PLATE
1	D4074-1	BRACKET
1	D4074-3	CHANNEL
1	D4074-5	BACKING PLATE
1	D4074-7	STRIKER PLATE
1	D4519-1	RELAY BRACKET
1	IN4007	DIODE
1	M12883-41-19	RELAY BASE
4	M39029/92-534	SOCKET CONTACT
1	M83536/9-024M	RELAY
20	MS21042L3	NUT (or MS21042-3)
1	MS21042L5	NUT (or MS21042-5)
8	MS27039-1-10	SCREW
2	MS27039-1-14	SCREW
8	MS27039-1-16	SCREW
1	MS27039-1-17	SCREW
18	NAS1149D0363J	WASHER (or AN960JD10)
1	NAS1149D0663J	WASHER (or AN960JD616)
4	NAS1515H-5L	WASHER

Qty -023	Part Number	Description
X	D139-799-023	ANTI-ROTATION BLOCK KIT
5	D4310-1	BLOCK, ANTI-ROTATION
10	MS24665-115	PIN, COTTER

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: 12.01.12	Job No.: RD2341	ADR Yes/No: N	ADR Date:	ECN #: 12- 507
Product No.: D139-799		Created By: RF	Approved By: <i>[Signature]</i>	
Product Name: Maintenance Kits		Checked By: <i>[Signature]</i>		

Distribution	Reqd	Resp	Initial / Date
Production Manager / Coord.	Y	LL/JLM	
Purchasing Coord.	Y	CL	
Production Engineering Coord.	Y	EC	

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord.	N		
QC Coordinator	N		
Customer Technical Support	Y	MB/DS	
Marketing	Y	SW	
Customer Order Processing	N		

Reason for Change: Add D139-799-023/025 kits and update D139-799-013 kits

Documents Affected:

MDL-D139-799 Rev. E	QR-D139-799-1 Rev. A
IIN-D139-799 Rev. F	ICA-D139-799 Rev. 5
D4519 Rev. A	D4456 Rev. A
M6061-OS Rev. A	

PARTS MUST COMPLY



PREVIOUS PARTS SATISFACTORY



#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	Y	SW	Send updated IIN & ICA	
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Master Document List (MDL)	Y	RF	MDL-D139-799 Rev. E	<i>[Signature]</i> 12.01.17
6	Update Product Compatibility Matrix	N			
7	Create Eurocopter Form (FEE)	N			
8	Notify TC / FAA of Change	N			
9					

#	Document Control Actions	Reqd	Resp	Notes	Complete
10	Move Electronic Files/Design Journal	Y	KJ		12.01.17 <i>[Signature]</i>
11	Update Product Specification Files	Y	KJ		12.01.17 <i>[Signature]</i>
12	Update Approved/Preliminary Dwg PDF Files	Y	KJ		12.01.17 <i>[Signature]</i>
13	Update Document Record (DR)	N			
14	Update Product Development Summary	N			
15	Update QSI 021 and/or STC Approval List	N			
16	Update Parts / STC Database	Y	KJ		12.01.17 <i>[Signature]</i>
17	Update / Verify ARC Database	Y	KJ		12.01.17 <i>[Signature]</i>
18	Create / Update Change Record Form / Item Card Database	Y	KJ	See note below	12.01.17 <i>[Signature]</i>
19	Create / Update PPP's	Y	KJ		
20	Red Decals required?	Y	KJ		
21	Update Document Control Database / Laminated Dwgs	Y	KJ		
22	Update Grey Project / Electronic Binder PDF Files	Y	KJ		12.01.17 <i>[Signature]</i>
23	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		12.01.17 <i>[Signature]</i>
24					

Description / Action:

Create BOM/routing for D4519 Rev. A and D4556 Rev. A and D139-799-023/-025 kits
D139-799-023 @ CHG 001 & D139-799-025 @ CHG 001
Update D139-799-013 kits in stock with additional parts per IIN - 7774/78000
Manufacture small quantities of D139-799-025 until kit has been tried.
D139-799-013 now @ CHG 004

REFERENCE ONLY

ECN Verified & Complete: _____ Date: _____

Qty -013	Part Number	Description
X	D139-799-013	CARGO DOOR HINGE KIT
1	D2585	MOUNTING CHANNEL
1	D2586	DOOR LATCH
1	D2621	LATCH PLATE
1	D3552-23	DOOR PROP
1	D3622-1	BALL STUD
1	D3622-3	BALL STUD
2	D4072-1	AIRFRAME HINGE
2	D4072-3	AIRFRAME HINGE BACKING PLATE
4	D4072-5	BUSHING
2	D4073-1	DOOR HINGE
2	D4073-3	DOOR HINGE BACKING PLATE
1	D4074-1	BRACKET
1	D4074-3	CHANNEL
1	D4074-5	BACKING PLATE
1	D4074-7	STRIKER PLATE
1	D4519-1	RELAY BRACKET
1	IN4007	DIODE
1	M12883-41-19	RELAY BASE
4	M39029/92-534	SOCKET CONTACT
1	M83536/9-024M	RELAY
20	MS21042L3	NUT (or MS21042-3)
1	MS21042L5	NUT (or MS21042-5)
8	MS27039-1-10	SCREW
2	MS27039-1-14	SCREW
8	MS27039-1-16	SCREW
1	MS27039-1-17	SCREW
18	NAS1149D0363J	WASHER (or AN960JD10)
1	NAS1149D0663J	WASHER (or AN960JD616)
4	NAS1515H-5L	WASHER

Qty -023	Part Number	Description
X	D139-799-023	ANTI-ROTATION BLOCK KIT
5	D4310-1	BLOCK, ANTI-ROTATION
10	MS24665-115	PIN, COTTER

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Revision: **F**
Date: 11.10.20

Status	Item ID	Rev	Name	Start Date	Quantity	Pe	UOM	Scrap %	Route	Seq	II	Sort	Comments	Date Last Mod	Stop Date
	D2585		Mounting Channel	6/8/2010	1.0000		Each	0 %	110			1		6/8/2010 10:...	
	D2586		Door Latch	6/8/2010	1.0000		Each	0 %	110			2		6/8/2010 10:...	
	D2621		Latch Plate, 350 Spacepod	6/8/2010	1.0000		Each	0 %	110			3		6/8/2010 10:...	
	D3552-23		Door Prop	10/17/2011	1.0000		Each	0 %	110			4		10/17/2011...	
	D3622-3		Ball Stud	10/13/2010	1.0000		Each	0 %	110			5		7/5/2011 10:...	
	D3622-1		Ball Stud	6/8/2010	1.0000		Each	0 %	110			5		6/8/2010 10:...	
	D4072-1		Airframe Hinge	6/8/2010	2.0000		Each	0 %	110			6		6/8/2010 10:...	
	D4072-5		Bushing	10/13/2010	4.0000		Each	0 %	110			7		7/5/2011 10:...	
	D4072-3		Airframe Hinge Backing Plate	6/8/2010	2.0000		Each	0 %	110			7		6/8/2010 10:...	
	D4073-1		Door Hinge	6/8/2010	2.0000		Each	0 %	110			8		6/8/2010 10:...	
	D4073-3		Door Hinge Backing Plate	6/8/2010	2.0000		Each	0 %	110			9		6/8/2010 10:...	
	D4074-1		Bracket	6/8/2010	1.0000		Each	0 %	110			10		6/8/2010 10:...	
	D4074-3		Channel	6/8/2010	1.0000		Each	0 %	110			11		6/8/2010 10:...	
	D4074-5		Backing Plate	6/8/2010	1.0000		Each	0 %	110			12		6/8/2010 10:...	
	D4074-7		Striker Plate	6/8/2010	1.0000		Each	0 %	110			13		6/8/2010 10:...	
	D4519-1		Relay Bracket	1/19/2012	1.0000		Each	0 %	110			14		1/19/2012 1:...	
	MS21042L3		Nut	6/8/2010	20.0000		Each	0 %	110			15		10/13/2010...	
	MS21042L5		Nut	6/8/2010	1.0000		Each	0 %	110			16		6/8/2010 10:...	
	MS27039-1-10		Screw	6/8/2010	8.0000		Each	0 %	110			18		7/5/2011 10:...	
	MS27039-1-14		Screw	10/13/2010	2.0000		Each	0 %	110			19		7/5/2011 10:...	
	MS27039-1-16		Screw	7/5/2011	8.0000		Each	0 %	110			20		9/27/2011 9:...	
	MS27039-1-17		Screw	6/8/2010	1.0000		Each	0 %	110			21		6/8/2010 10:...	
	NAS1149D0363J		Washer	6/8/2010	18.0000		Each	0 %	110			22		10/13/2010...	
	NAS1149D0663J		Washer	6/8/2010	1.0000		Each	0 %	110			23		6/8/2010 10:...	
	NAS1515H5L		WASHER	10/13/2010	4.0000		Each	0 %	110			24		7/5/2011 10:...	
	IN4007		Diodes	1/19/2012	1.0000		Each	0 %	110			25		1/19/2012 1:...	
	M12883/41-19		Relay Base	1/19/2012	1.0000		Each	0 %	110			26		1/19/2012 1:...	